

Date: Monday, 24/11/2008 10:21:28 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 43707		
Estimate Number	: 12785		
P.O. Number	:	Part Number	: D356411
This Issue	: 24/11/2008 S.O. No. :	Drawing Number	: D3564 REVD
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 43192	Material	:
Written By	:	Due Date	: 02/12/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>MF 08-11-24</u>		
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 1.4805 sf(s)/Unit Total: 29.6100 sf(s)  
 M304S16GA Stainless steel sheet 0.063" thick  
 Batch: 189057 B 8-11-27

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\*  
 Dwg Rev: D B 8-11-27  
 Prog Rev: D



2-Deburr if necessary B 8-11-27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/11/27 +

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Deburr if necessary  
 Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155

SA 08/11/28 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: WEARPAD

Job Number: 43707

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Ensure joggle as per dwg D3429

*Scrub 29 counter (422)*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	M109963
Weld hardcoat as per Dwg D3437		

*FL 8-12-1 (122)*

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*06.12.02 (22)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06.12.02 (22)*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*9:00  
320 °C  
9:30*

*M-1 08/12/02 (22x)*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-12-02 (22)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*FP-19 M-1 08/12/02 (22x)*

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Drawing Name: WEARPAD

Job Number: 43707

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/02  
*[Signature]*

Job Completion



~~MF~~  
MF 08-12-02

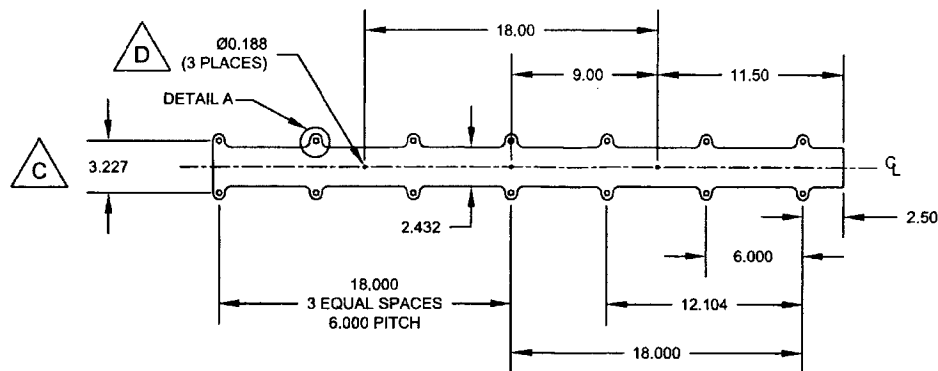
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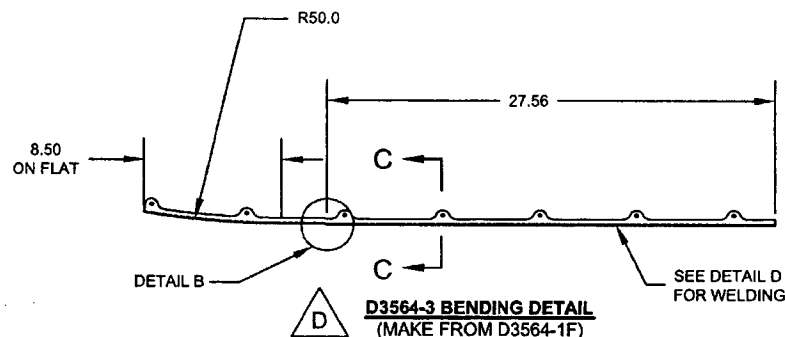
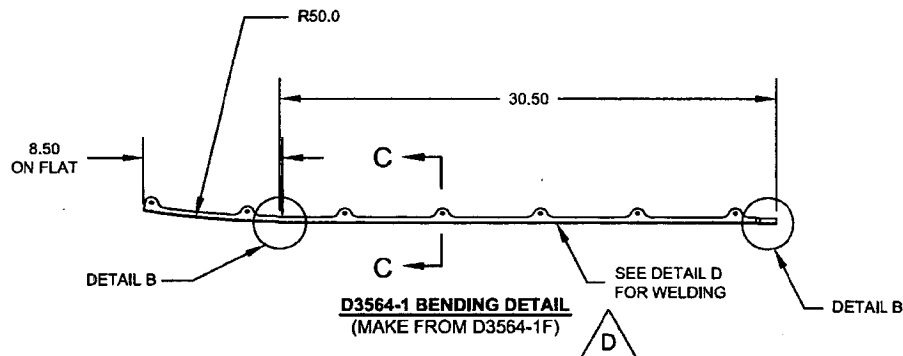
**NOTE:** Date & initial all entries



**D3564-1F FLAT PATTERN**

**RELEASED**

07.09.04



**REFERENCE ONLY**

Mo 45707

**564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)

FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.015 MAX

IDENTIFICATION: NONE

WEIGHT: SEE TABLE IN ZONE A3

WELD PER DART QSI 004

SEE PG 3 FOR SECTIONS AND DETAILS

) PARTS ARE SYMMETRIC ABOUT C

**WEIGHTS:**

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B8, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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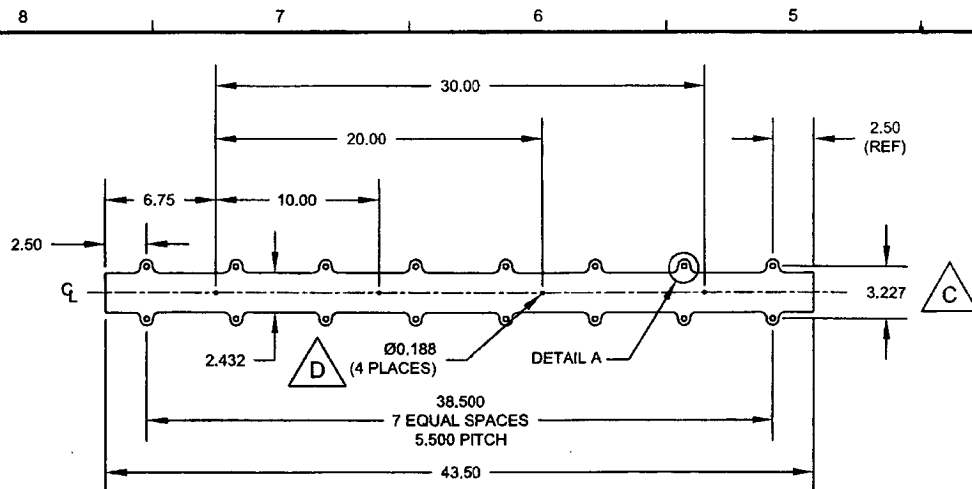
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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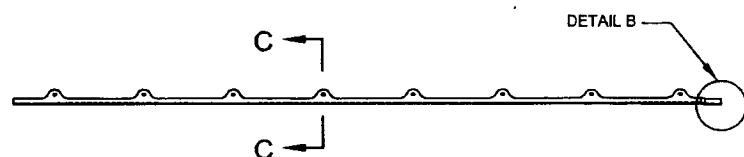
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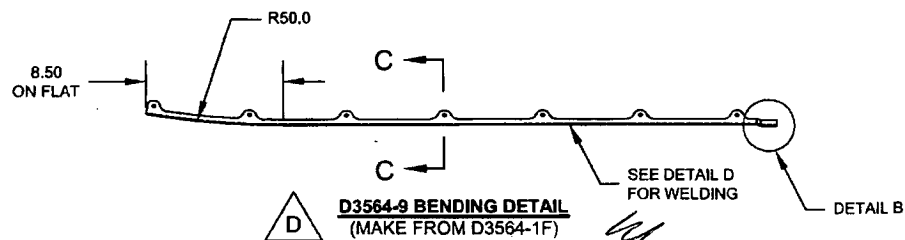




**D3564-5F FLAT PATTERN**



**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)

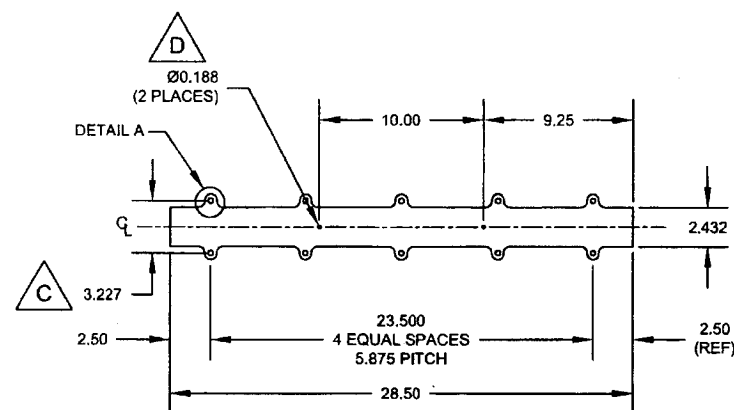


**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)

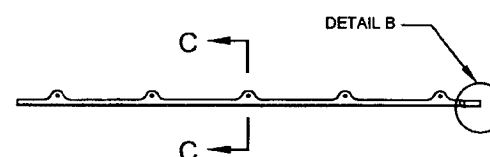
**REFERENCE ONLY**

*Mo 43707*

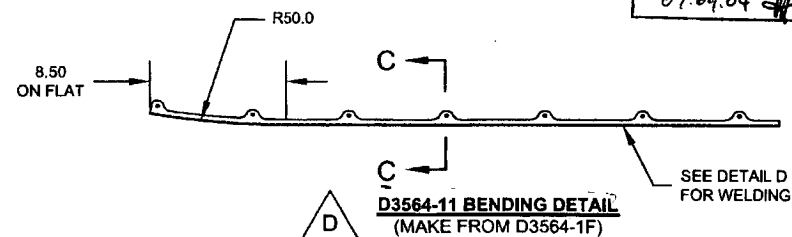
*REFERENCE*



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

**RELEASED**

07.09.04

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	NO	TITLE	SCALE
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DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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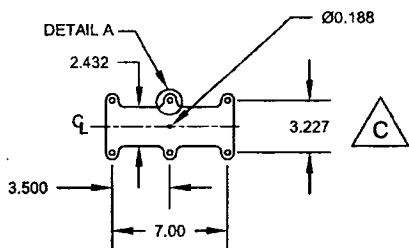
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

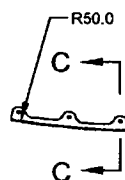
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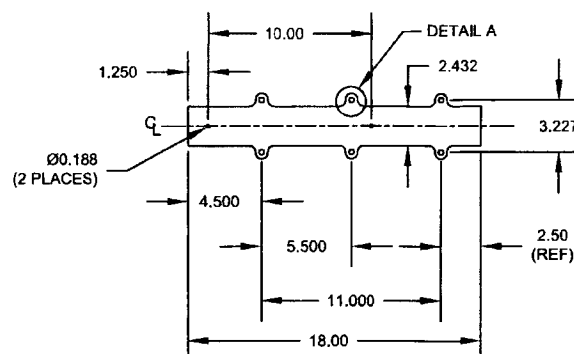
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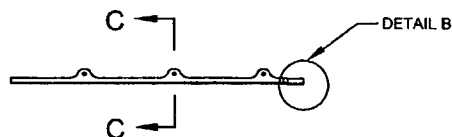
**D3564-13F FLAT PATTERN**



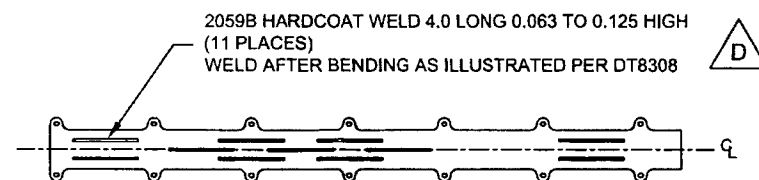
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**D3564-15F FLAT PATTERN**



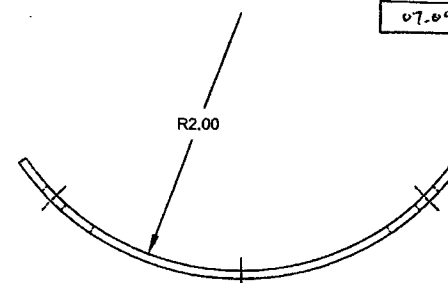
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)

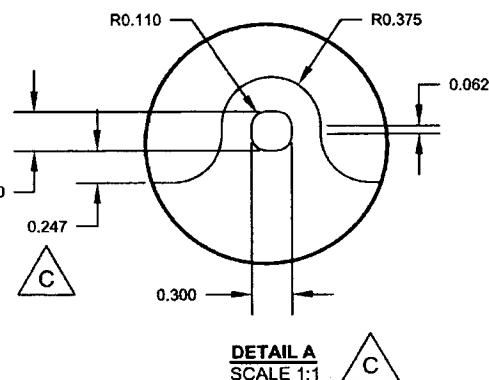
**RELEASED**

07.09.04

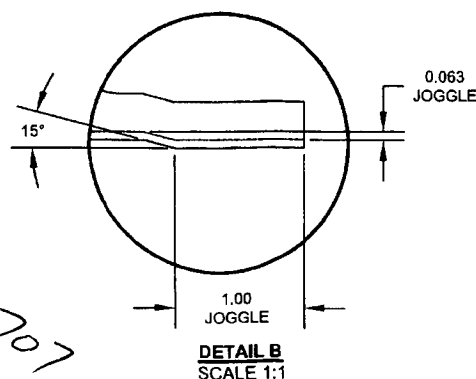


**SECTION C-C**  
SCALE 1:1

**REFERENCE ONLY**



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

*MO 43707*

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	CS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
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